

BLACK Sep 13/04

Work Order ID 57416

April 6, 2010 3:24:03 PM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 4/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG002
NON-EUROCOPTER

8/11/04/13

HJ for BG 10/04/12

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg
D3272

A/R Aluminum Rod

3-Grind End Plate flush

7/11/3/1
7/11/4/2

LG 10-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC Memo 0.00

Quality Control

① PD 1004.06

130 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

S. 10.64.07



140 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish Memo 0.00

Hand Finishing

10.04.07

1

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April 6, 2010 3:24:04 PM



Page 3

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

M-L 10/04/07

(IX)

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

- 1-Assemble Leg Assembly as per Dwg D3272.
- 2-Leave one rivet out until welding is complete.
- 3-Bevel Aft end for welding
- 4-Inspect for foreign object as per QSI 024
- 5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod ☐ *M111311*
- 6-Grind End Plate flush
- 7-Install last rivet as per Dwg.

10.04.07

1 of

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Work Order ID 57416

April 6, 2010 3:24:08 PM



Page 4

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190 QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

① D 10.04.08

200 QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10.04.08

±1
RH

210 Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

DL 10-4-8

1214

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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April 6, 2010 3:24:08 PM



Page 5

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M1105642

Powdercoat

Memo

0.00

Powder Coating

ATTN: POWDER COAT BLACK SANTEX PER QSI 005

START TIME: 10:15A-

OVEN TEMPERATURE: 320°C

FINISH TIME: 10:45A-

⇒ M 10/04/09

④ 0

230

Wing Walk as per dwg QSI005 4.4 Batch M113545

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-11-12

① R4

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Per 14/12 U

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April 6, 2010 3:24:14 PM



Page 6

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Required Date: 4/12/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312

Location: _____

HVS

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April 6, 2010 3:24:14 PM



Page 7

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/13 JF
P1 10-4-13
①

Dart Aerospace Ltd

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Picklist Print

April 6, 2010 3:23:51 PM

Page 1
7

Work Order ID: 57416



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 4/06/10

Required Date: 4/12/10

Comments: IPP Rev:A ☐ 04.03.22 ☐ New issue ☐ KJ/RF ☐

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:EC

D3065-041 Manufactured No

Each 14.0000 1.0000



Step Leg Assembly Hi

10.04.07

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

14

55450

14

D3066-1 Manufactured No

Each 44.0000 2.0000



Spacer

10.04.07

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

44

56752

44

D3219-1 Manufactured No

Each 65.0000 2.0000



Plate

10.04.07

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

65

56826

65

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April 6, 2010 3:23:52 PM

Page 2

Work Order ID: 57416



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 4/06/10

Required Date: 4/12/10

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:c

D3572-1

Manufactured No

Each

2.0000

1.0000



Step Modification

4/6/10



57568

[Signature]

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

2

57038

2

D3067-1

Manufactured No

110

Each

29.0000

1.0000



End Plate



12.10.04.07

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

29

57011

29

D3272-1

Manufactured No

110

Each

0.0000

1.0000



Step



357417 12.10.04.07

April 6, 2010 3:23:52 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April 6, 2010 3:23:52 PM

Page 3

Work Order ID: 57416

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Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

Start Date: 4/06/10

Required Date: 4/12/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

401.0000

2.0000



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

401

113523

26

113537

175

114108

200

M113537

MS20600-AD4W4

Purchased

No

180

Each

979.0000

16.0000



Rivets

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST321

979

113368

479

114181

500

16

AN3-35A

Purchased

No

260

Each

56.0000

2.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST353

56

112314

56

M112314

April 6, 2010 3:23:52 PM

Shop Packet Print

Page 3

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April 6, 2010 3:23:53 PM

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 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC

Start Date: 4/06/10

Required Date: 4/12/10

Start Qty: 1.00

Required Qty: 1.00

AN4-13A Purchased No 260 Each 47.0000 8.0000
 Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST357

47

114181

40

4828

7

AN5-36A Purchased No 260 Each 165.0000 2.0000
 Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST341

165

114292

165

AN960JD10 114292 260 Each 0.0000 4.0000
 Washer

AN960JD416 114292 260 Each 0.0000 16.0000
 Washer

AN960JD516 114292 260 Each 0.0000 4.0000
 Washer

April 6, 2010 3:23:53 PM

Shop Packet Print

Page 4

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April 6, 2010 3:23:53 PM

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 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:c

Start Date: 4/06/10

Required Date: 4/12/10

Start Qty: 1.00

Required Qty: 1.00

D2230-3 Manufactured No 260 Each 153.0000 4.0000
 Lug

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST476 153

56855 153

D2618 Manufactured No 260 Each 49.0000 2.0000
 Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST020 49

56892 49

D2856-400 Manufactured No 260 f 235.5600 0.6000
 Abraison Strip

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST403 235.56

50593 -1.2

52563 20.76

56626 216

April 6, 2010 3:23:53 PM

Shop Packet Print

Page 5

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 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

Start Date: 4/06/10

Required Date: 4/12/10

Start Qty: 1.00

Required Qty: 1.00

D3067-1 Manufactured No 260 Each 29.0000 1.0000
 End Plate
 Sh 10.04.07

Warehouse Loc Qty Loc Code
Location

Main Warehouse
 WA

29

57011

29

D3235-1 Manufactured No 260 Each 27.0000 2.0000
 Mounting Lug
 55315

Warehouse Loc Qty Loc Code
Location

Main Warehouse
 ST471

27

55315

27

D3278-041 Manufactured No 260 Each 25.0000 1.0000
 Support Assembly
 55318

Warehouse Loc Qty Loc Code
Location

Main Warehouse
 ST471

25

55318

25

April 6, 2010 3:23:54 PM

Shop Packet Print

Page 6

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 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

Start Date: 4/06/10

Required Date: 4/12/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No 260 Each 1,371.000-2.0000



Nut

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST300 1371

113537 387

113644 984

m113537

MS21042L4 Purchased No 260 Each 1,590.000 8.0000



Nut

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST139 2

111827 2

Main Warehouse

ST300 1588

113422 580

114108 1000

9063 8

m113422

April 6, 2010 3:23:54 PM

Shop Packet Print

Page 7

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DESIGN <i>GP</i>	DRAWN BY <i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET



GENERAL NOTES:

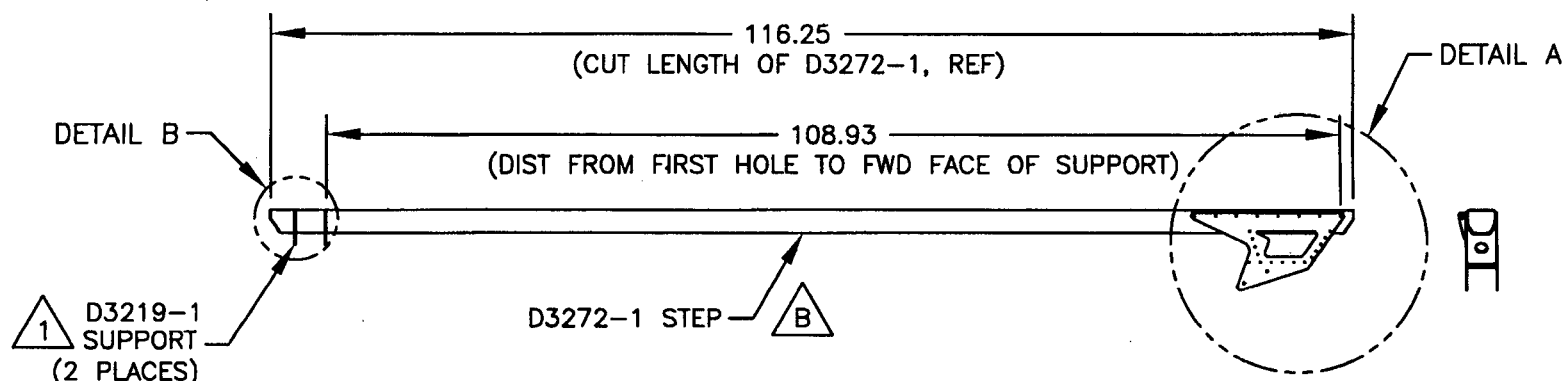
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

who
5746

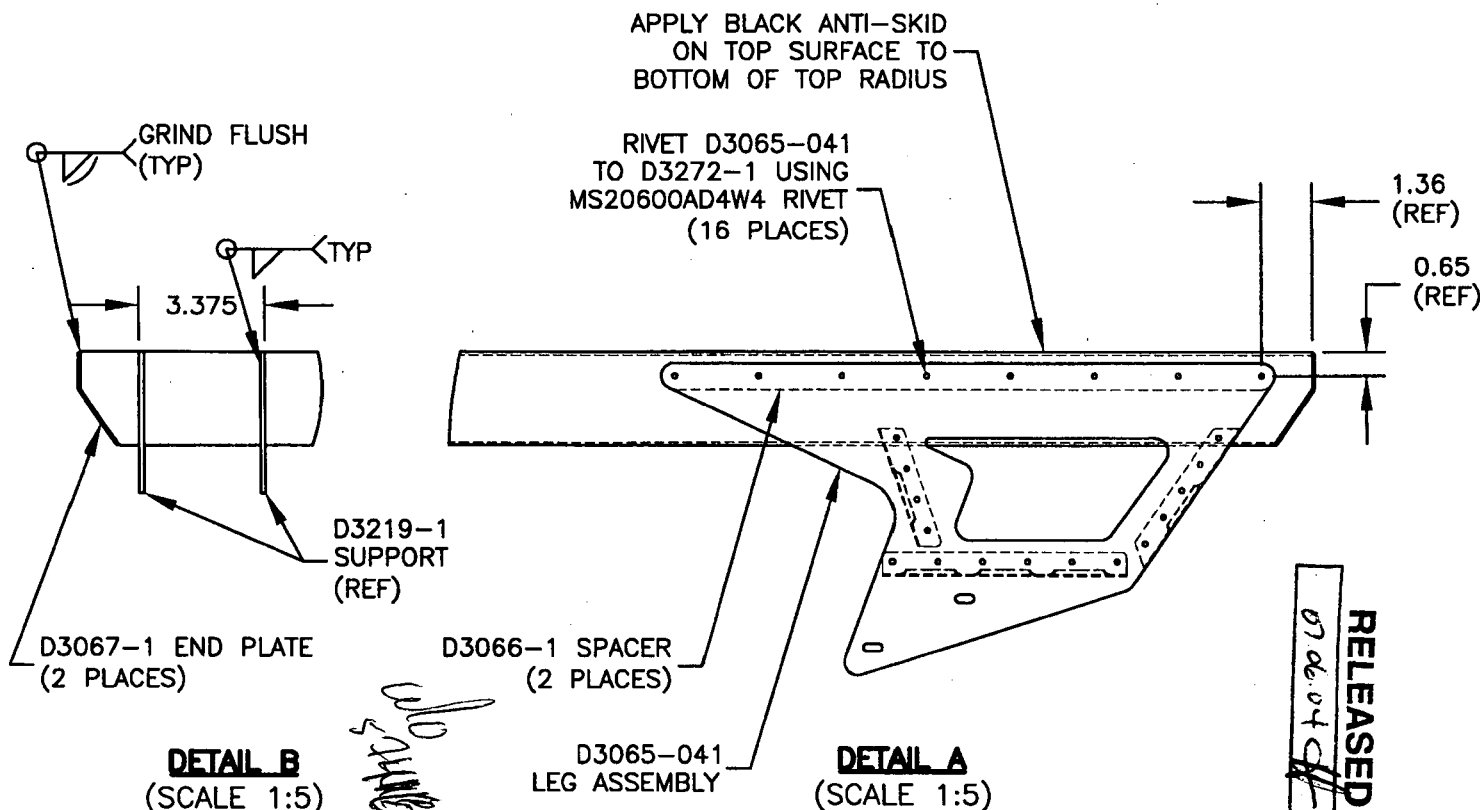
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DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



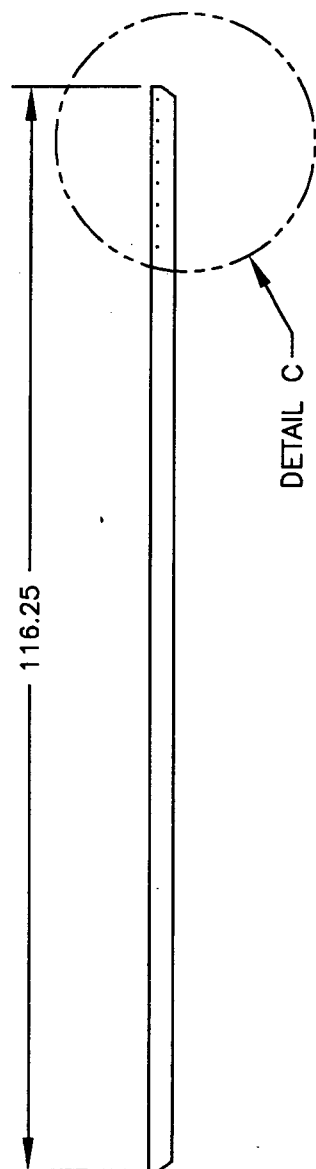
DESIGN	APPROVED	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE		DRAWING NO.	REV. B
07.05.18		D3272	SHEET 2 OF 3
		TITLE	SCALE
		STEP ASSEMBLY, HI LONG	1:20



DESIGN <i>90</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

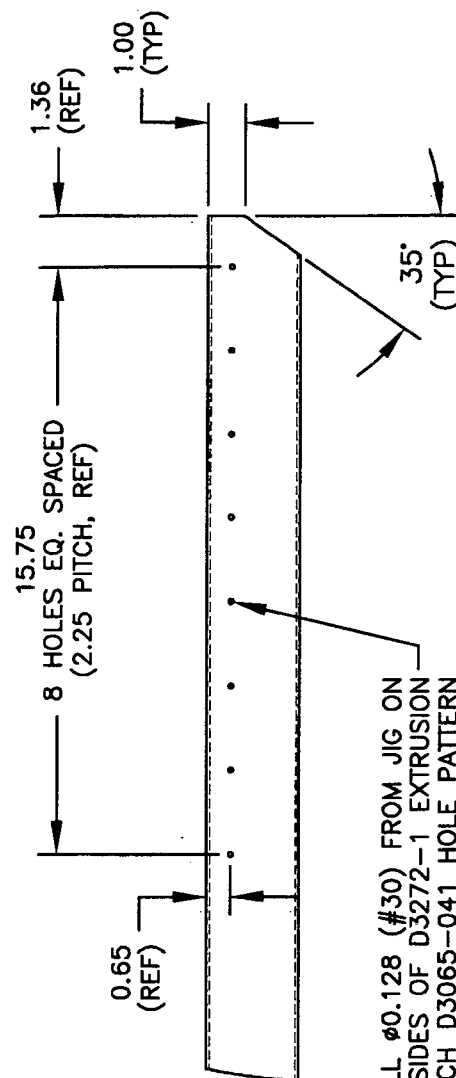
RELEASED

07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

WLO 5/4/06

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4		D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries